

# Work Order ID 57529

April 8, 2010 8:12:29 AM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 4/08/10 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

B 10-4-14

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-4-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

6/10/04/14

(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57529**

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Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 4/08/10

Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location

0.00



Packaging

Memo

0.00

Packaging

10-4-15 (120) SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/19 SP

MF 10-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 8, 2010 8:12:29 AM

Page 1

Work Order ID: 57529

Parent Item: D3536-23

Parent Item Name: Gasket


Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Date: 4/08/10

Required Date: 4/15/10

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063  NEOPRENE SHEET 0.063		Purchased	No			100	sf	378.0000	16.8821			

B10-4-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT052

114176

378

378

114176

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 57529
Description: Gasket		Part Number: D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

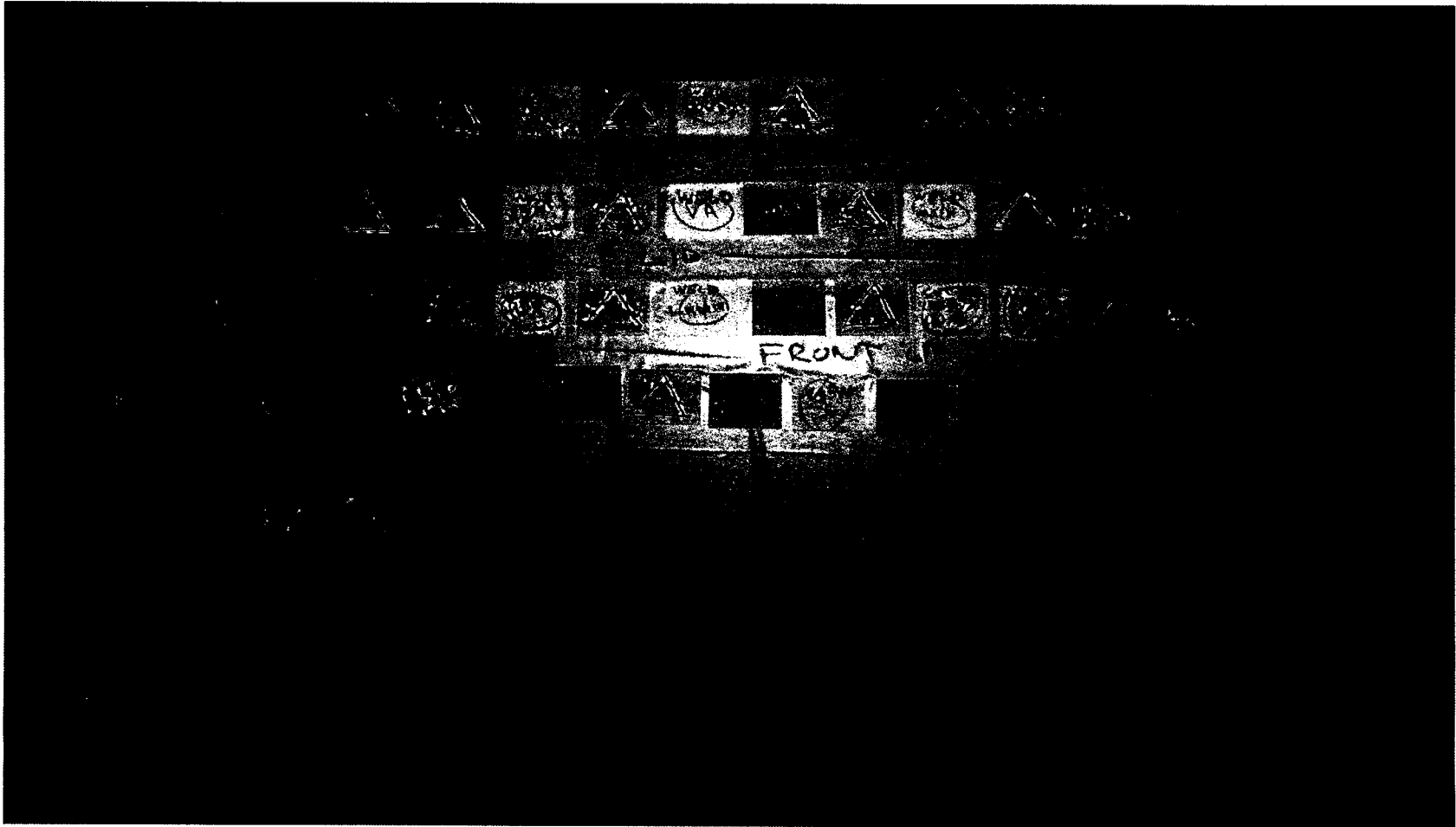
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	✓			
48.20	+/-0.030	48.20	x			
44.70	+/-0.030	44.70	x			
39.31	+/-0.030	39.31	✓			
33.92	+/-0.030	33.92	x			
28.53	+/-0.030	28.53	✓			
23.14	+/-0.030	23.14	x			
17.75	+/-0.030	17.75	x			
14.25	+/-0.030	14.25	x			
9.50	+/-0.030	9.50	x			
4.75	+/-0.030	4.75	✓			
8.00	+/-0.030	8.00	x			
16.00	+/-0.030	16.00	o			
24.00	+/-0.030	24.00	x			
32.00	+/-0.030	32.00	x			
39.00	+/-0.030	39.00	x			
48.00	+/-0.030	48.00	x			
0.30	+/-0.030	.303	o			
0.30	+/-0.030	.301	✓			
1.89	+/-0.030	1.888	x			
Ø0.19	+0.005/-0.001	.190	✓			

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-4-14	Date: 10/6/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

# Value stream mapping during Kaizen event.

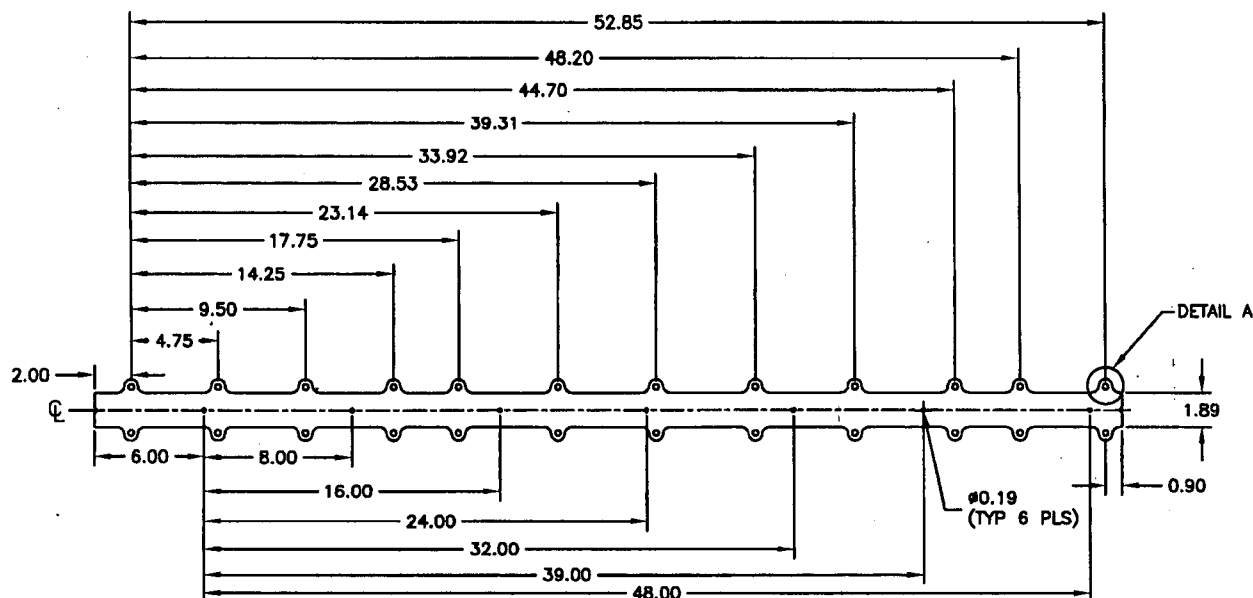




**DART**

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

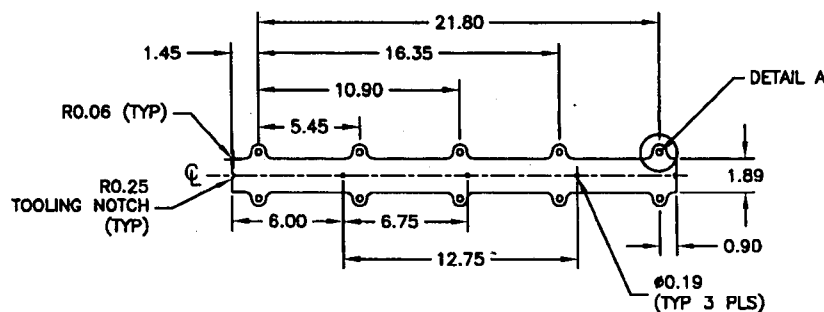
070212  
PH



**D3536-23 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



**D3536-25 GASKET**

W/o 57529



# Lean principle

To be able to produce exactly:

- **what is required**
- **when it is required**
- **the quantity required**

by the next step in the process.

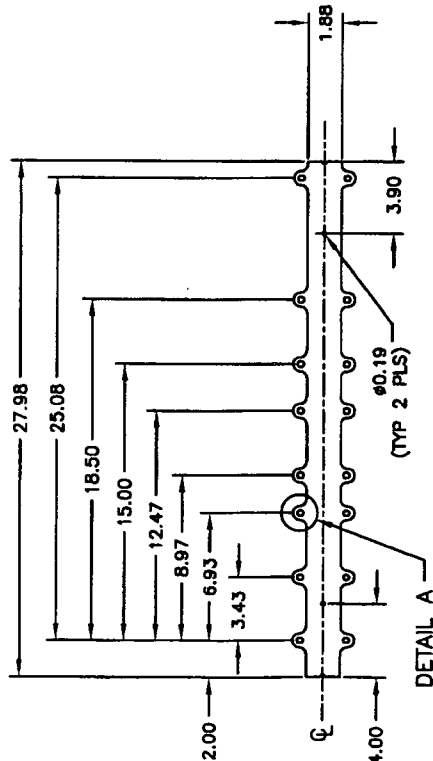
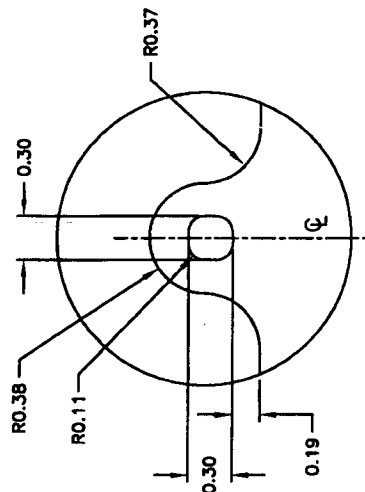
**Once a job started, it should ideally never stop**



DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3536</b>	REV. A SHEET 6 OF 6
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SCALE <b>1:10</b>	

070212 *[Signature]*

**DETAIL A**



**D3536-41 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

*w/0 57529*

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# Value stream mapping

- Value stream mapping is **the best way to identify where the high payoff** opportunities are, yet value stream mapping is the lean tool most likely to **not be used by** companies doing pretend lean!